

Thursday, 02/04/2009 1:27:11 PM

User:

Julie Dawson

## Process Sheet

<b>Customer</b>	: CU-DAR001 Dart Helicopters Services	<b>Drawing Name</b>	: BASKET RIB
<b>Job Number</b>	: 46867		
<b>Estimate Number</b>	: 10402		
<b>P.O. Number</b>	:	<b>Part Number</b>	: D31661
<b>This Issue</b>	: 02/04/2009 <b>S.O. No.</b> :	<b>Drawing Number</b>	: D3166 REV.A2
<b>Prsht Rev.</b>	: NC	<b>Project Number</b>	: N/A
<b>First Issue</b>	: / / <b>Type</b> : LARGE FAB ASSY	<b>Drawing Revision</b>	: A2
<b>Previous Run</b>	: 46628	<b>Material</b>	:
<b>Written By</b>	:	<b>Due Date</b>	: 08/04/2009 <b>Qty:</b> 12 <b>Um:</b> Each
<b>Checked &amp; Approved By</b>	: <u>JUD 09.04.02</u>		
<b>Comment</b>	: Est. A 02.08.23 New issue KJ Est. B 08.12.05 Updated bending program on step 3 per NCR W/O43165 KJ Verified by: EC Est Rev:C 09-01-23 as per DEO D3166-A2 DD verified by:EC		

## Additional Product

Job Number:



<b>Seq. #:</b>	<b>Machine Or Operation:</b>	<b>Description :</b>
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✓ 1.0	M304TS0750W065	304 SQ Tube .75x.75x.065W
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**Comment:** Qty.: 5.2500 f(s)/Unit Total: 63.0000 f(s)

304 SQ Tube.75x.75x.065W

(M304TS0750W065)

Material: 304/316 SS tube 0.065" wall

Batch

M111148SAD 09-04-05

2.0	SKIDTUBES 1	SKIDTUBESS RESOURCE 1
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**Comment:** LANDING GEAR RESOURCE 1

Cut 3/4" x 3/4" square tubing 60.00" long.

SAD 09-04-05

3.0	BENDING	BENDING MACHINE - SKIDTUBES
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**Comment:** BENDING MACHINE

-Form D3166-1 Basket Hoop as per Dwg D3166 using Bending program 350 BASB, and folio FT004.

PD 09-04-06 (9)

9-4-6

PTO

4.0	QC6	DIMENSIONAL CHECK
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**Comment:** DIMENSIONAL CHECK

Inspect Basket Hoop dimensions with template D3166-1-T1 (DT8302)

PD 09-04-06 (9)

5.0	PACKAGING 1	PACKAGING RESOURCE #1
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**Comment:** PACKAGING RESOURCE #1



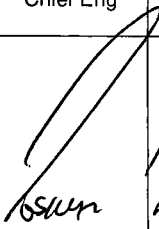
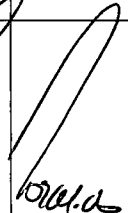
Identify and Stock

Location: BasketPD 09-04-06 (9)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: D3166-1 PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes ☒ No ☐ DQA: PD Date: 09/04/09

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR: <u>46867</u>		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
9-4-6	3	3 pcs Scrap Tried to improve band  R.C. continuous improvement		- scrap & destroy. - No replace	 9-4-6	PD 09-04-06		

NOTE: Date & initial all entries

Date: Thursday, 02/04/2009 1:27:11 PM  
User: Julie Dawson

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: BASKET RIB

Job Number: 46867

Part Number: D31661

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC21

FINAL INSPECTION/W/O RELEASE



09/04/08 *[Signature]*

Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



*u 9.04.07*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

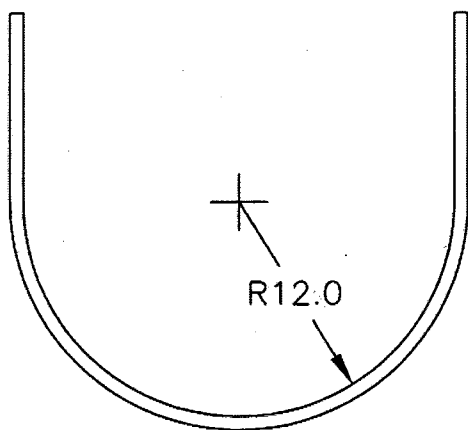
Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

**DART**

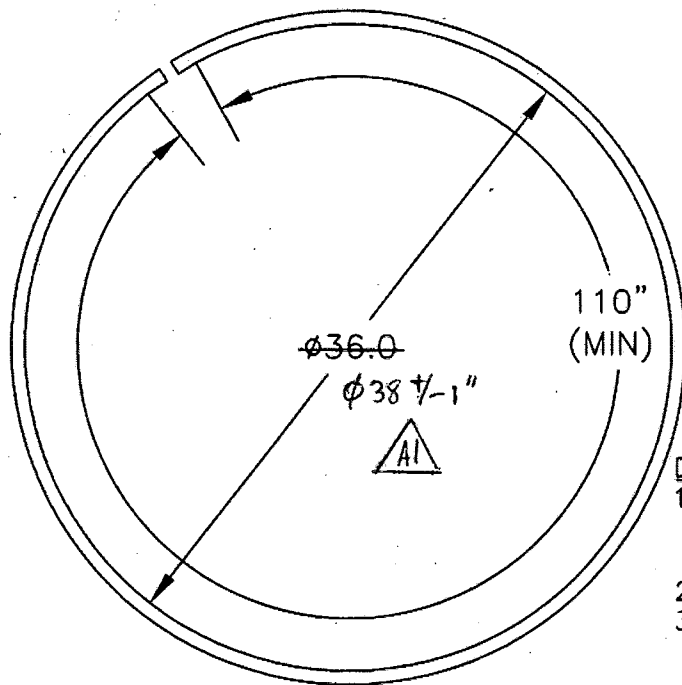
DESIGN #	DRAWN BY CP	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED #	APPROVED #	DRAWING NO. D3166	REV. A SHEET 1 OF 1
DATE 02.07.10		TITLE BASKET HOOP	SCALE NTS
A	02.07.10	NEW ISSUE	
A1	04.04.08	38+/- WAS 36.0	

**RELEASED**  
02.07.06

10.6 (REF, NEED 8.0 MIN)

**D3166-1 BASKET HOOP**

- 1) MATERIAL: AISI 304/316 SS SQUARE TUBING,  
0.75" x 0.75" x 0.063 WALL, 60.00" LONG  
(REF DART SPEC. M304TS0.750W.063)
- 2) FINISH: NONE
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS  
OTHERWISE NOTED



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UNCONTROLLED COPY  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER  
NO. 46867

**D3166-3 BASKET HOOP**

- 1) MATERIAL: AISI 304/316 SS SQUARE TUBING,  
0.75" x 0.75" x 0.063 WALL, 120.00" LONG  
(REF DART SPEC. M304TS0.750W.063)
- 2) FINISH: NONE
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS  
OTHERWISE NOTED

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

DRAWING NO. D3166	TITLE BASKET HOOP	REV A1	DART AEROSPACE LTD ENGINEERING ORDER		D.E.O. NO. D3166-A-2	SHEET NO. 1 OF 1	SCALE NTS
DRAWN AJS	CHECKED <i>[Signature]</i>	MFG. APPR. <i>[Signature]</i>	APPROVED <i>[Signature]</i>		DE APPR. <i>[Signature]</i>		
DATE 08.12.11	DATE 08.12.15	DATE 08/12/15	DATE 08/12/16		DATE 08.12.16		

1) MODIFY MATERIAL NOTE FOR D3166-1 AS SHOWN:

IS:

- 1) MATERIAL: AISI 304/316 SS, 3/4 X 3/4 X 0.065 WALL SQUARE TUBING,  
60.00" LONG  
REF. DART SPEC M304TS0.750W.065

WAS:

- 1) MATERIAL: AISI 304/316 SS SQUARE TUBING,  
0.75" x 0.75" x 0.063 WALL, 60.00" LONG  
(REF DART SPEC. M304TS0.750W.063)

2) MODIFY MATERIAL NOTE FOR D3166-3 AS SHOWN:

IS:

- 1) MATERIAL: AISI 304/316 SS, 3/4 X 3/4 X 0.065 WALL SQUARE TUBING,  
120.00" LONG  
REF. DART SPEC M304TS0.750W.065

WAS:

- 1) MATERIAL: AISI 304/316 SS SQUARE TUBING,  
0.75" x 0.75" x 0.063 WALL, 120.00" LONG  
(REF DART SPEC. M304TS0.750W.063)

REASON: SEE PAR 08-005

NO. 40807  
WORK ORDER  
WITHOUT NOTICE  
SUBJECT TO AMENDMENT  
ENGINEERING  
RETURN TO  
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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries